



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3403-5
Job Sheet 170273



Part No: D3403-5

Job Qty: 20 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/12/18

Job Tracking No:

Due Date: 1/26/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV E IPP REV:A NEW ISSUE 10-04-23 JLM VERIFIED BY:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Signature
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	1/25/18	1/25/18	0.00	0.00	Start Up Machining-2		DAS 23
100	Hardinge	20 pcs	1/26/18	1/26/18	0.08	3.01	Hardinge		9-89
120	QC	20 pcs	1/26/18	1/26/18	0.00	0.00	QC8		FX 18-1-28
130	Packaging	20 pcs	1/26/18	1/26/18	0.00	0.00	Packaging3-1		JAN 3 1 2018
140	QC21-SA	20 Ea	1/26/18	1/26/18	0.00	0.00	QC21		

Part Op Descriptions: 100 - 1- Turn as per Folio FA925 & Dwg D3403 Folio Rev: _____ Dwg Rev: _____

DAS
21

JAN 3 1 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M303R0.750	5	14	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.750inches ± 0.010	0.760 0.740		
2	Bushing	0.257inches + 0.010 - 0.000	0.267 0.257		
3	Bushing	0.060inches ± 0.005	0.065 0.055		
4	Bushing	2.420inches + 0.010 - 0.000	2.430 2.420		
5	Bushing	0.313inches ± 0.010	0.323 0.303		
6	Bushing	60Degrees ± 0	60 60		
7	Bushing	0.425inches + 0.000 - 0.002	0.425 0.423		
8	Bushing	0.030inches ± 0.010	0.040 0.020		
9	Bushing	20Degrees ± 0	20 20		
10	Bushing	0.010inches ± 0.010	0.020 0.000		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid
Part No. _____		Machine
NCR No. _____		Thermofor
		Large

Date : _____ Step #: _____ QTY _____

Description Work Order Deviation

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Root Cause

Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/C ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damaged ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	
Past Expiry Date ☐	Manufacturing Process ☐			
Misidentified ☐	Past Due ☐			
		OTHER : _____		

Dart Aerospace Ltd.
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Bushing

PART NO: D3403-5
Original Serial #: S036216
Revision:
Operation:
Change No:

Start up Operation 01/28/18
Job No: 170273

Engineering ☐
Quality ☐
Other ☐

12) Approval

Signed By

Supervisor
VerificationCoordinator
Initial
Wrong
Dimensions
or tolerance
or
missing

Off-set ☐
Mislabeled ☐
Fit/Function ☐
Misaligned/off center ☐

Drawing ☐
Finish ☐
Misread ☐
Turning Sequence ☐